



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3391-023
Job Sheet 184426



Part No: D3391-023

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Due Date: 11/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J SHEET 2 and 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/12/18	11/12/18	0.00	0.00	Start Up Skidtubes-1		
100	Skidtubes	1 pcs	11/12/18	11/12/18	0.88	2.11	Skidtubes-4		DAS 38
110	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		D.R. 18/11/25
120	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish1		60
130	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC7-2		9-89
140	Skidtubes	1 pcs	11/12/18	11/12/18	0.00	2.11	Skidtubes-4		BE
150	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		BE, Jy
160	Skidtubes	1 pcs	11/12/18	11/12/18	0.00	2.11	Skidtubes-4		38 DAS
170	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC10		9-89 38
180	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		9-89 38
185	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish2		D.R. 18/11/25
191	SprayPaint	1 pcs	11/12/18	11/12/18	0.00	0.91	Spray Paint		NIR
192	Outsource	1 pcs	11/12/18	11/12/18			ATE003-VC		CE 18-11-05
193	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging2		NOV 06 2018
200	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC14		20 38
230	HandFinish	1 pcs	11/12/18	11/12/18	0.00	0.38	HandFinish4		BE 18-11-05
240	QC	1 pcs	11/12/18	11/12/18	0.00	0.00	QC5		NOV 12 2018
250	Packaging	1 pcs	11/12/18	11/12/18	0.00	0.00	Packaging3-1		21 NOV 12 2018
260	QC21-SA	1 Ea	11/12/18	11/12/18	0.00	0.00	QC21		DAS 69 9-89

Part Op 100 - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1
Descriptions: fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle
holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of
skidtube as per Dwg D3391 6-Deburr, scibe batch # on aft end. 7- Locate D3391-021 in D3391-023 at 9.00" (see view
F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149
locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer
drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to
0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021
BATCH: 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker,
DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG Locating from two fwd wearplate holes in D3391-023
drill remaining 6 wearplte holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail
section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Environment _____ Design _____ Doc/Da _____ Equip/Tool _____ Handling/P _____ Mater _____ Internal Transp _____ Tribal Knowled _____ LC _____ Substat _____ Past Expiry Da _____ Misidentified ☐ ☐ Past Due ☐ OTHER : _____	DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S119728 Part: D3391 - 023 Job No: 184426 Serial No/Batch: S119728 Revision: J Inspector: Exp Date: Instructions: Various STC's Date: 11/06/18	GORY <table border="1"> <tr> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Misabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Misabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence
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Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside tube, scribe

140 - 1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: _____ batch#: _____

NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE

160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush

A/R B8673

185 - Re-alodine

197 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ PAINT AS PER DWG AND

QSI005 4.2.2.4 PAINT: 800 41598

230 - 1-Install Inserts as per Dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skidtube Extrusion	1 Ea (1 ea)	90-Start up Operation	B16253
D3389-1	Web	1 Ea (1 ea)	140-Skidtubes	5062811
D3681-1	Spacer	5 Ea (5 ea)	160-Skidtubes	5103210
ALS4-1032-130	Rivnut	20 Ea (20 ea)	230-HandFinish	5007279
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	5122431

M.U. 006289

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	32	0
140-Skidtubes	D3389-1	1	11	0
160-Skidtubes	D3681-1	5	257	0
230-HandFinish	ALS4-1032-130	20	12,131	0
	D3591-1	2	11	0

Part Specifications

Specifications could not be found.

Plex 10/9/18 1:12 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

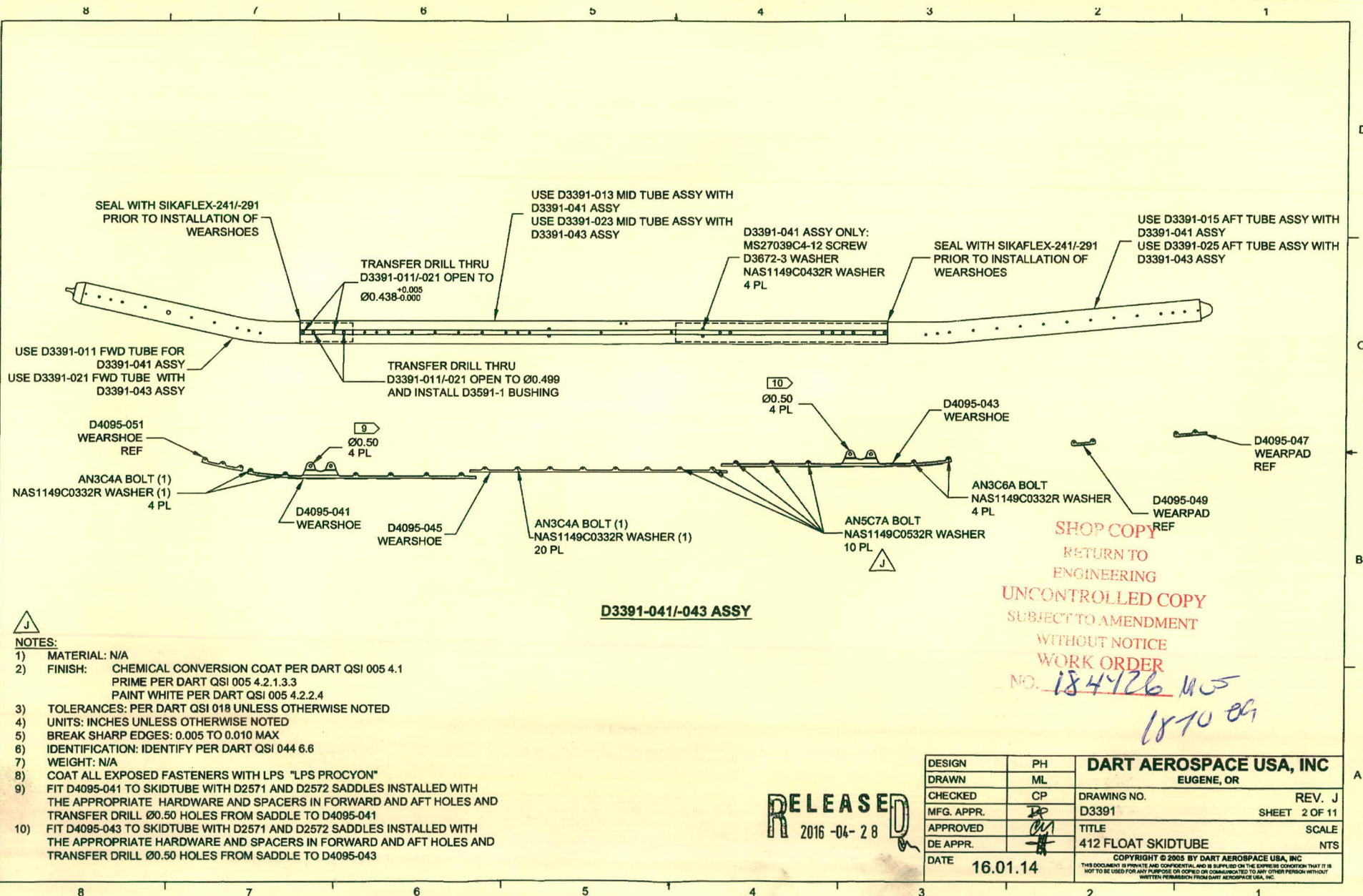


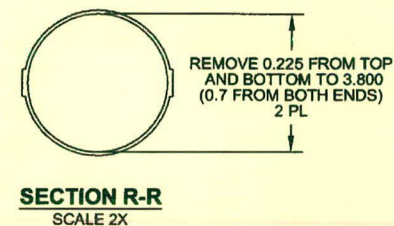
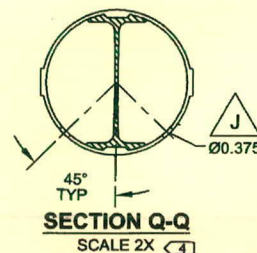
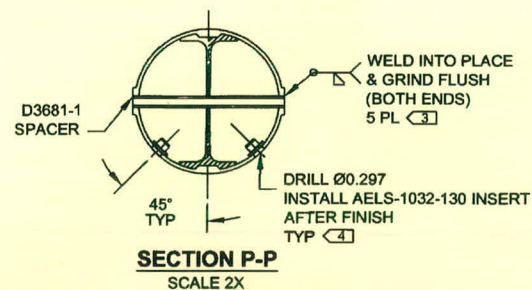
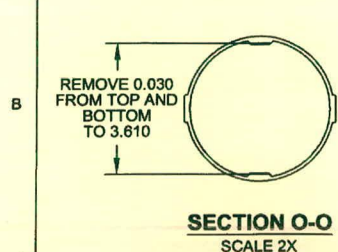
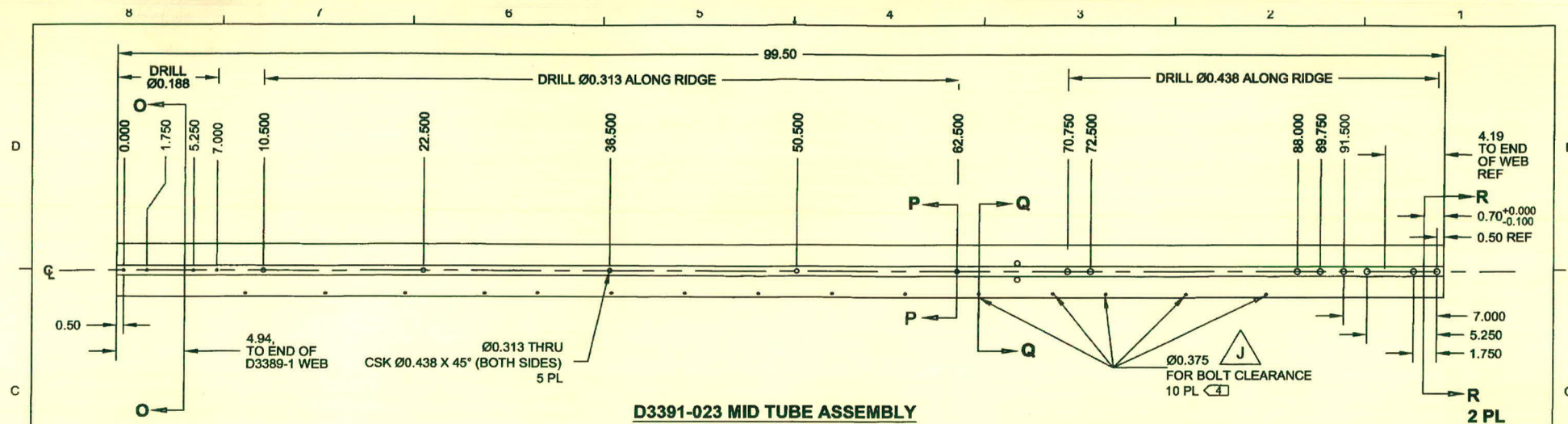
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					





D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY -023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT



D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

RELEASED
2016-04-28



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041598**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041598
PO Date: 11/5/18
Due Date: 11/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184660	D350-636-014	Skidtube RH, Std Wearplates, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2	Firmed	-	11/8/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	185413	D350-636-013	Skidtube LH, Std Wearplates, DART (Apical) Tri-Bag/Air Cruisers Float Comp. : TC STC SH99-7 Issue 2, FAA STC SR00646SE 15/10/28, EASA STC EASA.10033942 11/02/21, BRAZIL 2009S05-01 09/05/08 1- PRIME AS PER DWG AND QSI 005 4.2	Firmed	-	11/8/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
3	184426	D3391-023	PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT:	Firmed	-	11/8/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
	184426			Firmed	-	11/8/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Sub Total:							2	0	2		\$450.00

Grand Total: \$900.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041598

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/5/18 2:30 PM dart.tsimiklis.chrisoula

